

Date: Monday, 3/19/2007 8:17:49 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER ADAPTER FLANGE
Job Number	: 31276		
Estimate Number	: 12310		
P.O. Number	: <i>N/A</i>	Part Number	: D34775
This Issue	: 3/19/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3477 REV A
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 28568	Material	: <i>N/A</i>
Written By	:	Due Date	: 3/23/2007 Qty: 4 Um: Each
Checked & Approved By	: <i>9/07.03.19</i>		
Comment	: Est Rev:A New Issue 06-03-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.1817 sf(s)/Unit Total : 0.7266 sf(s) *0.9083*

304/316 0.018 SHEET

Batch: ~~*M102393*~~ *M102393 ml 07 03 20*

*(4)*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

Cut as per Dwg D

Dwg Rev: *A ml 07 03 20*

Prog Rev: *A*

*(4)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



*ml 07 03 20*

*(4)*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



*07 03 20*

Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Form as per Dwg D3477 using Dt8858 A,B&C

*03*




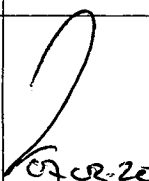
*07/03/21*

*(4)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
ml 07 03 20	2.0	1 scrap due to hole's were <del>to big</del> out of tolerance by 0.004 Jct offset was to big	 as1a12	Scrap and Replace reduce offset.	ml 07 03 20	 07 03 20	 as1a12	 07 03 20

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:17:50 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER ADAPTER FLANGE

Job Number: 31276

Part Number: D34775

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/21 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G.A.

mf. 07-03-26 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/27 (4)

Job Completion



07-03-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3477</b>	REV. A SHEET 1 OF 4
DATE <b>05.12.09</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2
A	05.12.09	NEW ISSUE	

*06.04.03*D3477-5 BLOWER  
ADAPTER FLANGE (1)D3477-3  
TUBE (1)D3477-1  
FLANGE (1)ALIGNMENT OF  
SPOT WELD SEAM $\phi 7.13$   
(REF)

(2 PLACES)

 $\phi 0.50$   
(24)

30°

45°

30°

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WORK ORDER  
NO. **31276****D3477-041 BLOWER MOTOR INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3477-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

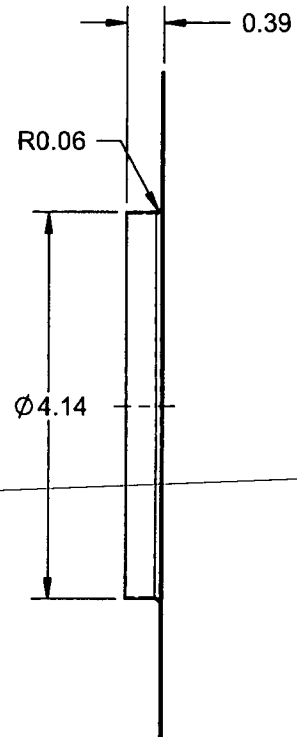
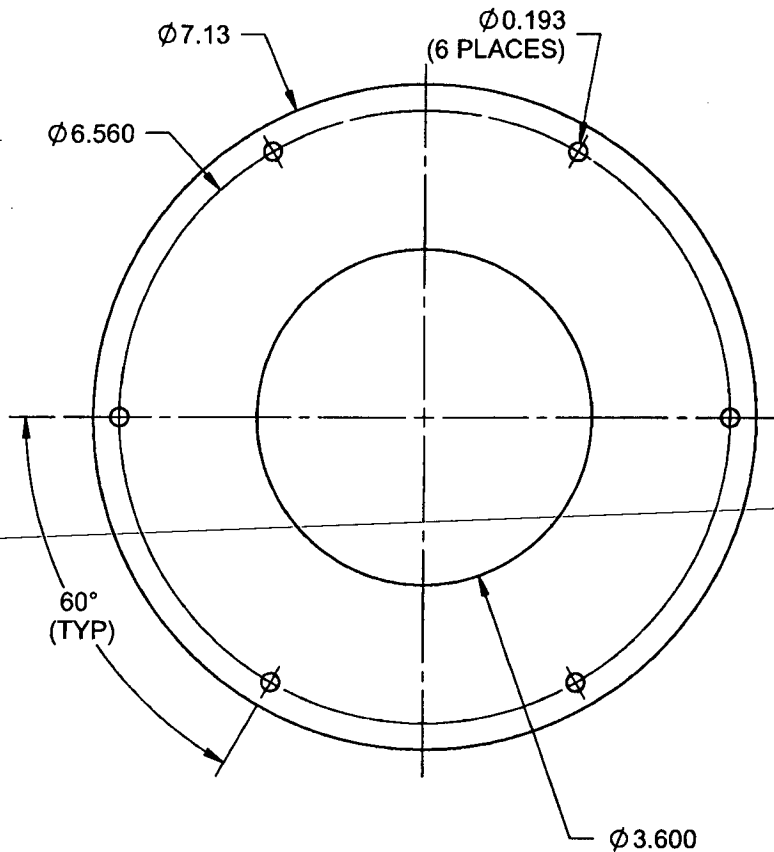
QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

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DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2

*H* 06.04.03**D3477-1F FLANGE  
FLAT PATTERN****D3477-1  
FLANGE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER  
NO. 31276

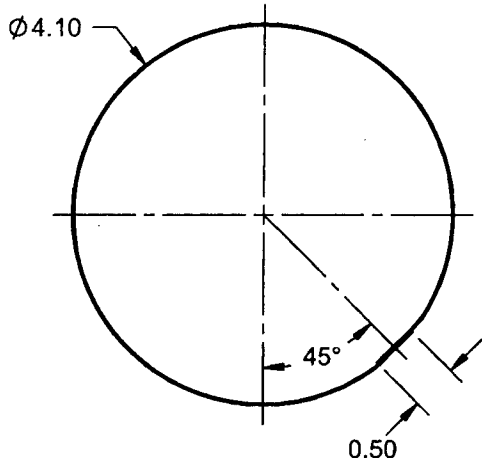
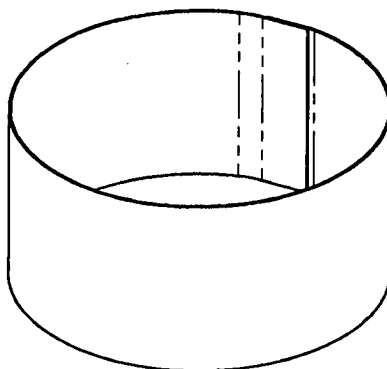
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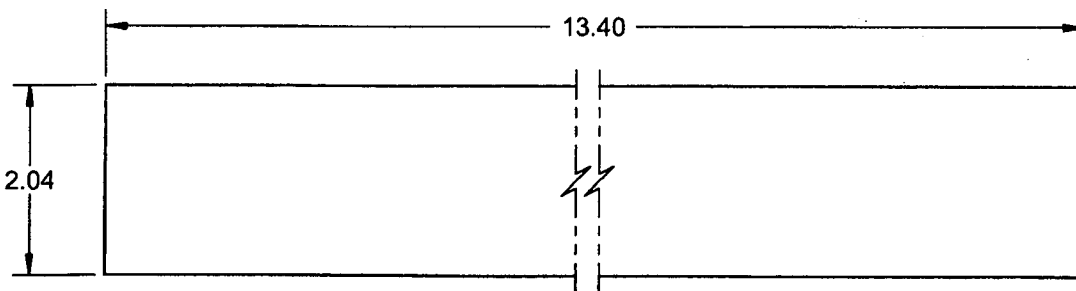
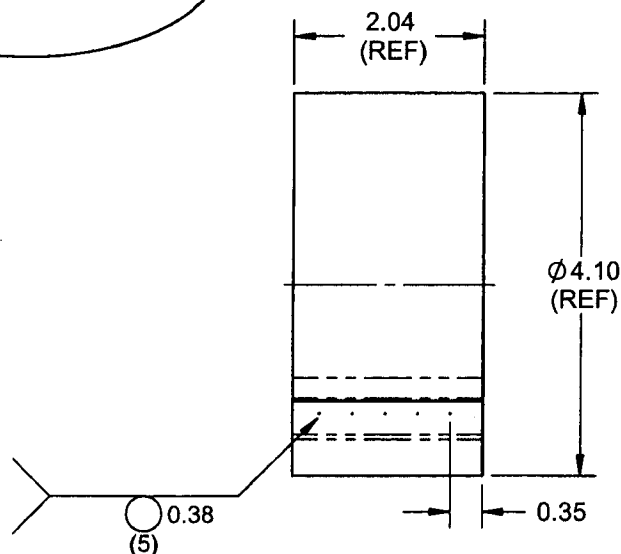


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DATE <b>05.12.09</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

# 06.04.03



**D3477-3 TUBE**



**D3477-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. **31276**

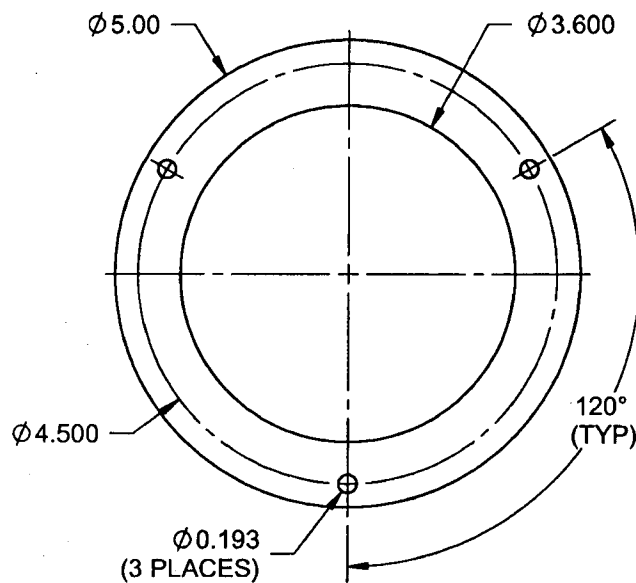
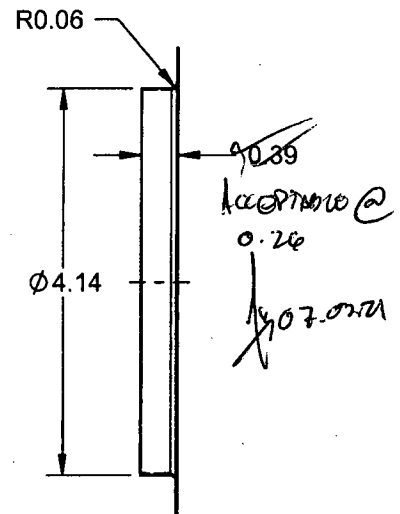
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DATE <b>05.12.09</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

*# 06.04.03***D3477-5F FLAT PATTERN****D3477-5 BLOWER  
ADAPTER FLANGE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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